2 16:12 PM						•			Page 1
tart Qty: 8.00 teq'd Qty: 8.00		Accept				s s			
me	Date: 10-11-16	Tooling: SPC (Y/N):			_	R			
peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Oty	Reject Otv	Reject Number	Insp. Stamp
on Nbr								- Trainior	Stamp
OW WATER JET : Memo 1-Cut as per Deburr if ne	Dwg D3319 .□Dwg Rev cessary	0.00 0.00 □Prog Rev:	& □2-		-	BI	0-1(-1	1(9
C2- Inspect parts off m Memo	achine FAI/FAIB	0.00				ഥ	1 <u>0-11-1</u> -	7	
	dart Qty: 8.00 eq'd Qty: 8.00 eq'd Qty: 8.00 Oeration escription n Nbr Owwater Jet : Memo 1-Cut as per Deburr if ne	dart Qty: 8.00 eq'd Qty: 8.00 Date: 10-11-16 Date: Deration escription n Nbr OW WATER JET Memo 1-Cut as per Dwg D3319 1-Dwg Rev Deburr if necessary	Accept tart Qty: 8.00 eq'd Qty: 8.00 Date: O-//-/6 Tooling: Date: SPC (Y/N): Deration Secription Nbr OW WATER JET: Memo 1-Cut as per Dwg D3319 Deburr if necessary C2- Inspect parts off machine FAI/FAIB 0.00	Accept Lart Qty: 8.00 eq'd Qty: 8.00 Date: Dollor: SPC (Y/N): Deteration Set Up/ Run Hours Nbr OWWATER JET: Memo 1-Cut as per Dwg D3319 Dwg Rev: SPC Deburr if necessary C2-Inspect parts off machine FAI/FAIB 0.00 0.00	Accept Lart Qty: 8.00 eq'd Qty: 8.00 Date: Date: SPC (Y/N): Date: Deration Set Up/ Run Hours OWN WATER JET ? Memo 1-Cut as per Dwg D3319 Dwg Rev: SProg Rev: 22-Inspect parts off machine FAI/FAIB Own Water Jet ? Own Wate	Accept Accept Cust Item ID: Customer: Date: 10-1/-16 Tooling: Date: Date: SPC (Y/N): Date: Deration Set Up/ Run Hours Owwwater Jet : Memo 1-Cut as per Dwg D3319 Dwg Rev: 10-000 Customer: Date: Dat	Accept Accept Cust Item ID: Customer: Pate: Date: Date: SPC (Y/N): Date: Date: SPC (Y/N): Date: Department on Set Up/ Run Hours OWWATER JET: OWW WATER	Accept Accept Setup Start Stop Cust Item ID: Customer: Pate: Date: Date: SPC (Y/N): Date: Stop Date: SPC (Y/N): Date: Code Qty Qty Nbr OWWATER JET: 0.00 OW WATER JET: 0.00 OW WATER JET: 0.00 OW WATER JET: 0.00 OW WATER JET: 0.00 Cust Item ID: Customer: Run Start Stop Run Start Tool ID Tool # Plan Accept Reject Code Qty Qty OW Qty Nbr	Accept Accept Setup Start Stop Lart Qty: 8.00 Eq'd Qty: 8.00 Date: O- - Date: SPC (Y/N): Date: Date: SPC (Y/N): Date: Department of Run Hours O.00 OW WATER JET: Memo 1-Cut as per Dwg D3319 Dwg Rev: \(\begin{array}{cccccccccccccccccccccccccccccccccccc

120

Quality Control

QC8- Inspect parts - second check

Memo

2000 Saluly

(45)

D u	Johago								
W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No C)QA:	Date: _	
	Re	esolution:	Disposition	າ:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NO	CR)			
		Description of NC		Corrective Action Sec	tion B	Ve	rification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& _S	ection C	Chief Eng	QC Inspector
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Wark	Orde	r ID	638	42
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Tuesday, November 16, 2010 1:16:12 PM



Page 2

Item ID:

D3319-3

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name: Start Date:

Wearplate

11/17/2010

Start Qty: 8.00 Rea'd Oty: 8.00

Date:

Cust Item ID:

Customer:

Reference:

An	prova	ls:
771	71 7 4	

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Qty



QC:

Required Date: 11/24/2010

Sequence ID/

Operation

Set Up/ Run Hours Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

130

Work Center ID

Small Fab

Small Fab

Description

Small Fab

Memo Deburr if necessary 0.00

0.00

١, 0.00

140

Brake NC

NC BRAKE

0.00

SB 10/11/22

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: _

150

QC

6/8/11/22

Quality Control

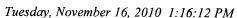
Memo

QC6- Inspect dimensions to drawing

Memo

	1											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No		PAR #:	Fault Categ	jory:	ICR: Yes	No DQ	A:	Date:				
	Re	esolution:	Disposition	:	A: N/C CI	osed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	R)						
DATE	STEP	Description of NC		Corrective Action Section E		Verification		Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector			
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Wo	rk	Ord	ler	ID	6384	7
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Page 3

Item ID:

D3319-3

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Wearplate

Required Date: 11/24/2010

11/17/2010

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: Tooling:

Date: _____

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run

Start

Stop

Reject

Reject

Qty

Stop



Number Stamp

QC: ___

Sequence ID/

Work Center ID

160

Large Fab

Large Fab

Operation Description

Large Fab

Set Up/ **Run Hours**

0.00

0.00

Memo

Memo

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: □Qty Part Number Description

7560 Hardcoat Rod

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Accept

Qty

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Sidnilos

									
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:		
	Re	esolution:	Disposition	ı:	_ QA: N/C C	losed:		Date: _	
NCR:		V	VORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector

Work Order ID 63842

Tuesday, November 16, 2010 1:16:12 PM



Page 4

Item ID:

D3319-3

Accept

Setup Start

Stop

Stop

9 Bl 11-01-26



Revision ID:

Item Name:

Wearplate

Start Date: Required Date: 11/24/2010

11/17/2010

Start Oty: 8.00 Req'd Qty: 8.00

Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Start Run



Qty

Reject

Accept

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

190

Powdercoat

Powder Coating

Operation **Description**

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

Memo START TIME: OVEN TEMPERATURE:

0.00

0.00

200

QC

QC3- Inspect Part Finish

Memo

0.00

0.00

11/01/26

Quality Control

210

Packaging

Packaging

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3319-3, B/N: BXXXXX□For Product Eligibility see PDA05-18□and

Stock Location: 497

[u/u/2- (4)

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CHANGE	ES				, , , , , , , , , , , , , , , , , , , 	
DATE	STEP	PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						# # # # # # # # # # # # # # # # # # #				
Part No	:	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQ	A:	Date: _	<u> </u>
	Re	esolution:	Dispositi	on:	QA: N	C Clo	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	NCE (I	NCR)	:			
		Description of NC		Corrective Action Section	n B	,	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	I	ign & Date		ion C	Chief Eng	QC Inspector
	1				1					

Work Order ID 63842

Tuesday, November 16, 2010 1:16:12 PM



Page 5

Item ID:

D3319-3

Accept



Date:

Date:

Setup Start

Stop

Start

Stop



Revision ID:

Item Name:

Wearplate

Start Date: 11/17/2010

Required Date: 11/24/2010

Start Qty: 8.00

Reg'd Qty: 8.00

Cust Item ID: Customer:

Reference:

Ap	pro	val	s:
7.5	P . U	,	

Process Plan:

QC:

Operation

Description

Date:

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Reject Qty Qty

Run

Reject Number

Insp. Stamp

Work Center ID 220

Sequence ID/

QC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

W. Luol 27

W/O:		WORK ORDER CHANGES					:
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	_
Resolu	tion:	Disposition:	QA: N/C Closed	l :	Date:	

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Picklist Print

Tuesday, November 16, 2010 1:16:11 PM

Work Order ID: 63842

Parent Item: D3319-3

Parent Item Name: Wearplate



Start Date: 11/17/2010

Required Date: 11/24/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: A□05.05.12□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 06-10-03 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No		100	sf	34.0000	3.2524	27.38863	3		
										B10-11	•	

1010/1025 SHEET .048

Location Loc Qty Loc Code MAT 34 116031 34



	Uspace								
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								i	
		<u> </u>							
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C Cld	sed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC			on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
								7-5-11-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1	
·									

DART AEROSPACE LTD	Work Order:	63842
Description: Wearplate	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing	T-1	Actual	A 4	Delega	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
75.52	+/-0.030	75.52	×		T B01	
74.420	+/-0.010	74.420	3		τ	
62.770	+/-0.010	62.770	2		Т	
52.890	+/-0.010	678.67	2		7	
30.790	+/-0.010	30.790	a		7	
8.690	+/-0.010	8.690	>		T	
0.60	+/-0.030	,6000	X_		UB02	
2.690	+/-0.010	2.698	W		V	
2.940	+/-0.010	2.949	y		V	
3.527	+/-0.010	3,524	Se		U	
4.518	+/-0.010	4.518	X		V	
Ø0.190	+0.005/-0.001	.194	X		V	
2.940	+/-0.010	2,950	Jer .		V	
2.940	+/-0.010	2,949	×		V	
2.690	+/-0.010	2,700	æ		J	-
5.063	+/-0.010	5.059	*		V	
6.163	+/-0.010	6.164	R		٢/	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	317×609	æ		Ĭ	
0.048	+/-0.010		*		V	

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	10-11-17	Date: (O((()(5)	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No):	PAR #:	PAR #: Fault Category:		NCR: Yes N	lo DQA:	Date: _	
Re		olution:	n: (QA: N/C Clo	Date:			
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC			Section B		Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspecto

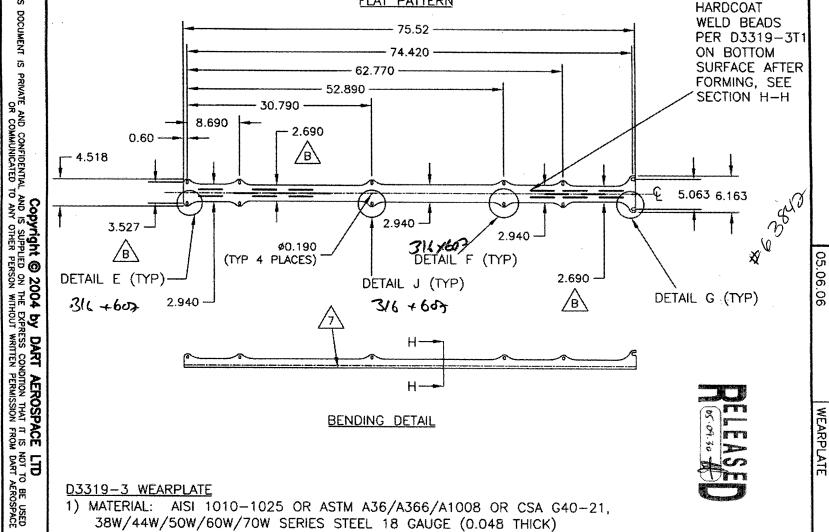
•		Description of NC			COLLECTIVE VOLIDIL Section D	•	Verification	Approval	Approval
DATE	STEP Description of NC Section A	٠	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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APPLY 7560

D3319

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REV. B



FLAT PATTERN

D3319-3 WEARPLATE

DOCUMENT

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ANY

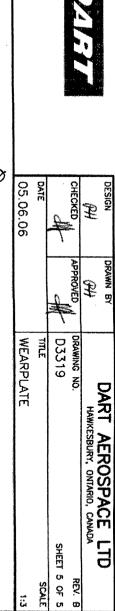
PURPOSE

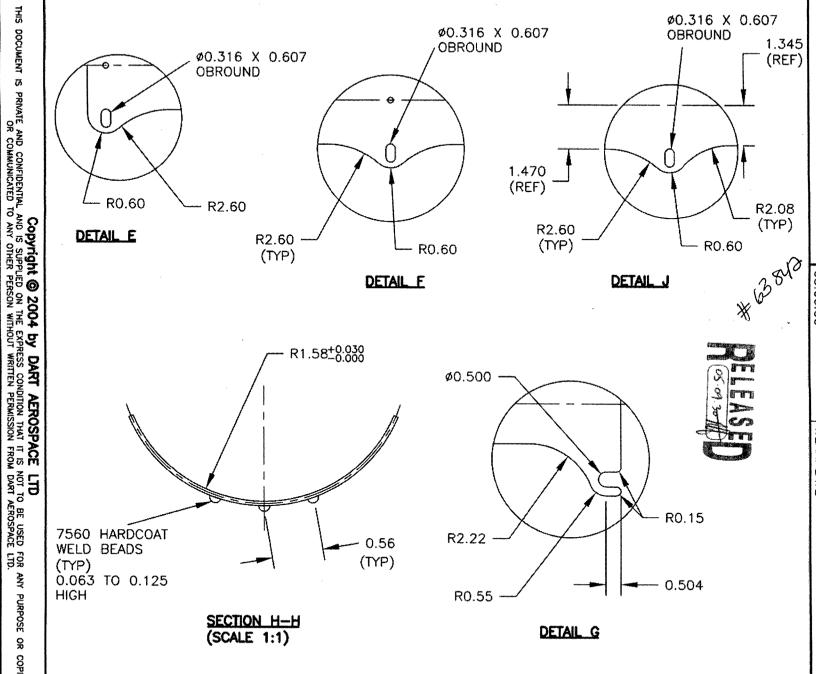
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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 2) FINISH:
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng /	Approval QC Inspector				
							Prod Mgr	QO Mapoctor				
							·					
							:					
						•						
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:							
Resolution:			Disposition	on:	QA: N/C Clo	: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)							
		Description of NC	on B	Verification	cation Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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W/O:	-		WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:PAR		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition	1:	_ QA: N/C C	QA: N/C Closed:			
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	7)			
DATE	OTED	Description of NC		on B	Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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